

Date: Friday, 20/02/2009 10:58:03 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 45929		
Estimate Number	: 10442		
P.O. Number	:	Part Number	: D32623
This Issue	: 20/02/2009 S.O. No. :	Drawing Number	: D3262 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 43642B	Material	:
Written By	: <u>JLP 09-02-20</u>	Due Date	: 27/02/2009 Qty: 6 Um: Each
Checked & Approved By	:		
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .500 x 6.00
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Comment: Qty.: 0.9668 f(s)/Unit Total : 5.8010 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
 (M6061T6B0.500x06.000)
 Identify for D3262-3
 Batch: 110912 JLP 09/02/20

(6)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 6.000" x 0.500" x 5.400" long Bar
 Machine as per Folio FA457 and Dwg D3262
 Identify for D3262-3
 Deburr

JLP 09/02/20

(6)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per dwg D3262

J.F. 09/02/20

(6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/02/21

(6)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SP 09/02/23

(6)

Date: Friday, 20/02/2009 10:58:04 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 45929

Part Number: D32623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST163

09/02/23 (X6)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



mf
09-02-23



DART AEROSPACE LTD		Work Order:	45929
Description: Cap		Part Number:	D3262-3
Inspection Dwg: D3262 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

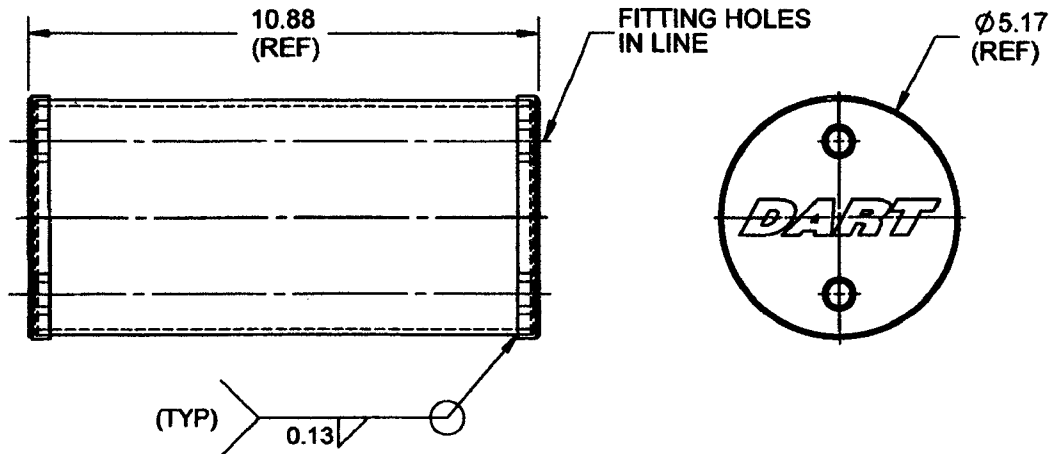
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	.060"	✓			
0.45	+/-0.030	.455"	✓			
R0.063	+/-0.010	R.063"	✓			
0.080	+/-0.010	.082"	✓			
0.33	+/-0.030	.329"	✓			
Ø5.005	+0.010/-0.000	Ø5.008"				
0.688	+0.015/-0.000	.700"	✓			
3.25	+/-0.005	3.245"	✓			
0.875	+/-0.010	.874"	✓			
Ø0.516	+0.005/-0.000	Ø.518"	✓			
Ø5.165	+/-0.010	Ø5.167"	✓			
0.083	+0.015/-0.000	.083"	✓			
Ø0.580	+0.005/-0.000	Ø.580"	✓			

Measured by:	J.F.	Audited by:	JP	Prototype Approval:	N/A
Date:	09/02/21	Date:	09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM	<div style="display: flex; align-items: center;"> <div style="margin-right: 20px;">  </div> <div>  </div> </div>


DART

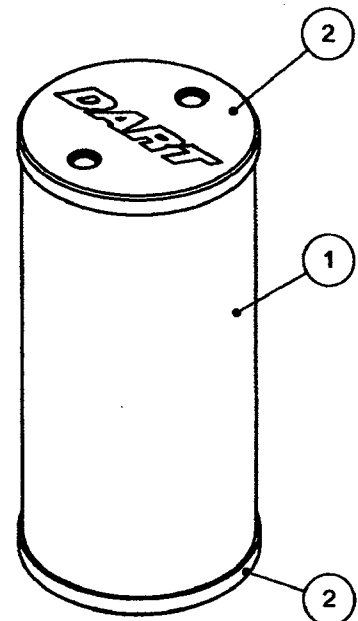
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø 5.165 WAS Ø 5.190	

RELEASED06.09.19 *[Signature]**w/o 45924***D3262-041 CANISTER ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

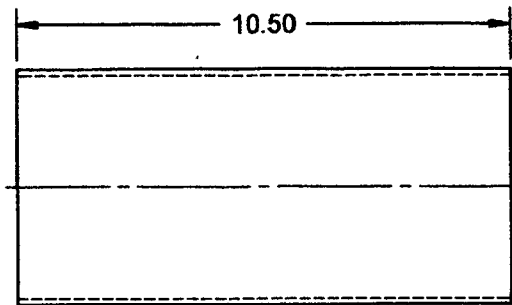
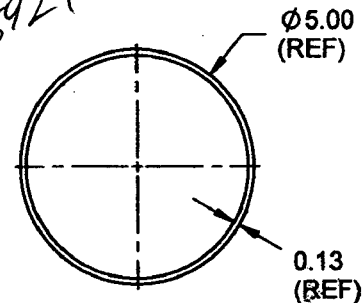
- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS 
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

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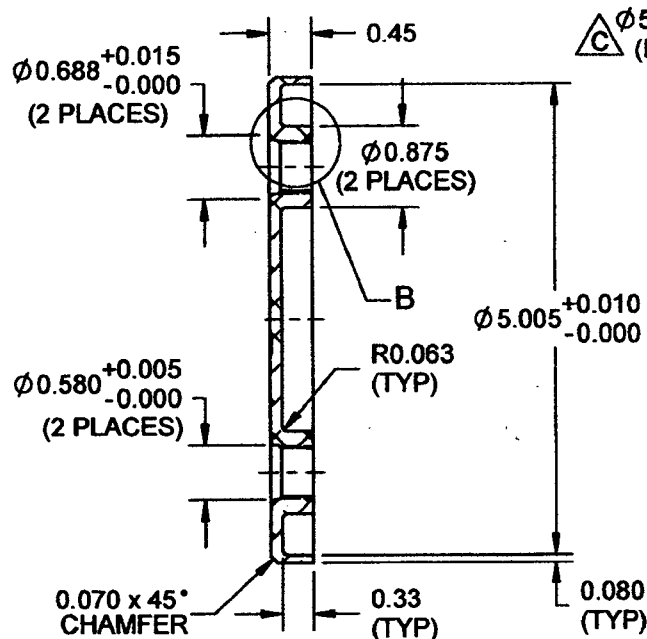
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DART

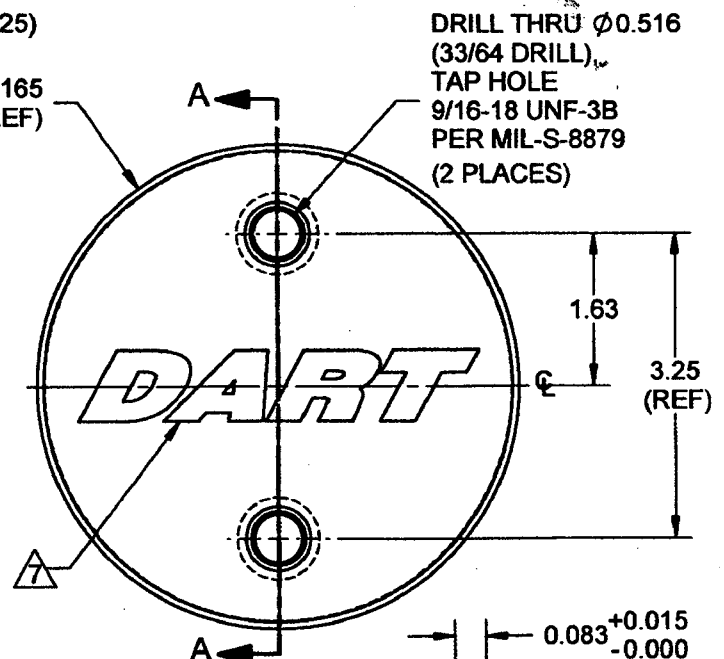
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.08.31	TITLE FUEL PURGE CANISTER		SCALE 1:4

*w/045929***RELEASED***06.09.11***D3262-1 TUBE**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



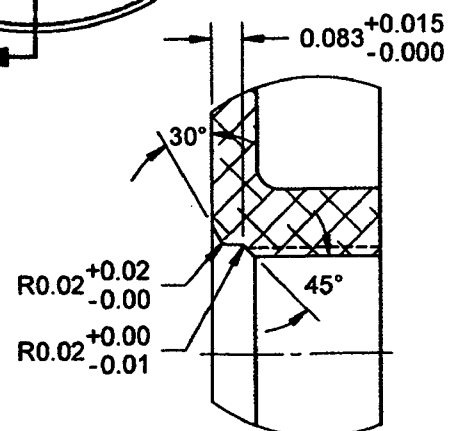
SECTION A-A
SCALE 1:2

**D3262-3 CAP**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)



DETAIL B
SCALE 2:1

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